

12/02 28/02

Dart Aerospace Ltd.

Split

Date: Friday, 09/01/2009 11:03:14 AM
User: Julie Dawson

Process Sheet

| | | | |
|-----------------------|---|------------------|--------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : INBOARD LEG ASSY |
| Job Number | : 44524 | Part Number | : D3684045 |
| Estimate Number | : 13174 | Drawing Number | : D3684 REV B |
| P.O. Number | : | Project Number | : N/A |
| This Issue | : 09/01/2009 S.O. No. : | Drawing Revision | : B |
| Prsht Rev. | : NC | Material | : |
| First Issue | : / / Type : MACHINED PARTS | Due Date | : 26/01/2009 |
| Previous Run | : 38481 | Qty: | 3 Um: Each |
| Written By | : | | |
| Checked & Approved By | : <u>JLD 09.01.09</u> | | |
| Comment | : Est Rev:A new issue 08-02-12 DD verified by:JLM Est Rev:B As per Rev B 09-01-07 JLM Verified By:EC | | |

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

2.0 D36885 STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

STUD

batch

B44685

EP 09/04/16

3.0 D36891 SLEEVE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

SLEEVE

batch

B44825

EP 09/04/16

4.0 D36911 STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

STUD

batch

B45485

EP 09/04/16

5.0 D36921 SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

SPACER

batch

B44689

EP 09/04/16

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INBOARD LEG ASS'Y

Job Number: 44524

Part Number: D3684045

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|--------|-----------------|
| 6.0 | D36931 | Rod End Bearing |
|-----|--------|-----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Rod End Bearing

batch B44828

EP 09/04/16

| | | |
|-----|---------|-------|
| 7.0 | AN3C12A | Bolts |
|-----|---------|-------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolts

batch M110155

M110552

EP 09/04/16

| | | |
|-----|----------|-----|
| 8.0 | MS210433 | Nut |
|-----|----------|-----|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

batch M111041

EP 09/04/16

| | | |
|-----|------------|------|
| 9.0 | NAS509L12C | Nuts |
|-----|------------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Nuts

batch M106993

EP 09/04/16

| | | |
|------|-----------|------|
| 10.0 | NAS50912C | Nuts |
|------|-----------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Nuts

batch M106993

EP 09/04/16

| | | |
|------|-------------|-------------------------------|
| 11.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|------|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Use anti-seize compound on thread and assemble as per dwg D3684

EP 09-04-29

| | | |
|------|-----|------------------------------|
| 12.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|------|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/29 (x3)

(3)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INBOARD LEG ASS'Y

Job Number: 44524

Part Number: D3684045

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

ST 139c

14.0

QC21

FINAL INSPECTION/W/O RELEASE



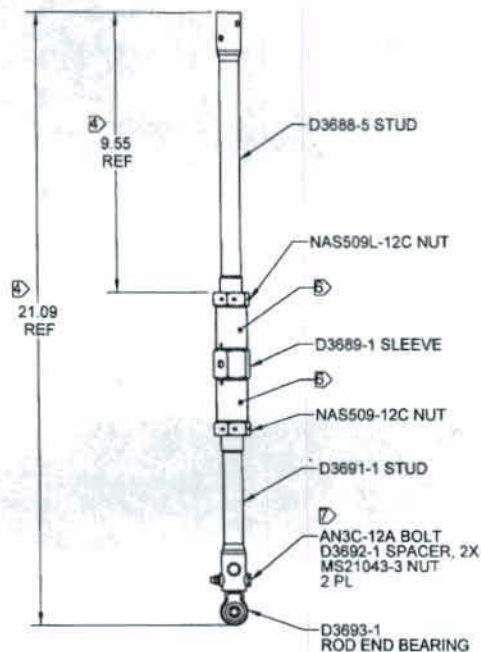
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-04-30

| ITEM | QTY .045 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|----------------------|
| 1 | X | D3684-045 | INBOARD LEG ASSEMBLY |
| 2 | 1 | D3688-5 | STUD |
| 3 | 1 | D3689-1 | SLEEVE |
| 4 | 1 | D3691-1 | STUD |
| 5 | 4 | D3692-1 | SPACER |
| 6 | 1 | D3693-1 | ROD END BEARING |
| 7 | 2 | AN3C-12A | BOLT |
| 8 | 2 | MS21043-3 | NUT |
| 9 | 1 | NAS509L-12C | NUT |
| 10 | 1 | NAS509-12C | NUT |



D3684-045 INBOARD LEG ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 44504

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-045
USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSION SHOWN IS WHEN D3688-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.1 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs

RELEASED
08/12/15

| | | | |
|------------|----------|---|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 91 | DRAWING NO. | REV. B |
| MFG. APPR. | 91 | D3684 | SHEET 3 OF 5 |
| APPROVED | 91 | TITLE | SCALE |
| DE APPR. | 91 | TRIPOD MOUNT ASSY | NTS |
| DATE | 08.11.24 | COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE TO THE PUBLIC ON THE BASIS OF THE OPEN SOURCE POLICY. IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR THE DISSEMINATION OF INFORMATION TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

